

Work Order ID 86831

86831

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July-06-12 3:02:42 PM

Item ID: D2151 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Packer Doubler, Hinge
 Start Date: 7/06/12 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 12-07-9 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2151	Rev B								

100 0.00
100 FLOW WATER JET 20 0 Jm 12-7-23
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2151 Dwg Rev: B Prog Rev: B 2-
 2029. 00 Debur if necessary

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB 20 0 Jm 12-7-23
 QC Memo 0.00
 Quality Control

120 0.00
120 QC8- Inspect parts - second check 20 _____
 QC Memo 0.00
 Quality Control

SMB 12-7-24 *DAS 16 8-8 12/14/24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Required Date: 8/03/12 Req'd Qty: 20.00 *20* Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr								
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:30								
	FINISH TIME: 10:00								

20 7/6/12 7:25

M-F
12/07/27

20 X 0

M121841

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Item ID: D2151

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Packer Doubler, Hinge

Start Date: 7/06/12 Start Qty: 20.00

20

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

20 6 BR 12-7-07

170

Identify as per dwg & Stock Location: 6

0.00

170

Packaging

Memo

0.00

Packaging

20 12/7/27sf

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/7/31 sfMCS 12/07/30

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 86831

Parent Item: D2151

Parent Item Name: Packer Doubler, Hinge

Start Date: 7/06/12

Required Date: 8/03/12

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP C00.10.23Re-format (mpp 2101)EC
IPP Rev:D 06-04-28 Manufactured on Water Jet JLM
IPP Rev:E 06-11-24 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			110	sf	178.1612	0.035	0.736842 0.8075			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT022		178.1611626							
				120605		49.6627416							
				121197		32.498421							
				122136		96				122136			

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DART AEROSPACE LTD		Work Order:	86831
Description: Packer		Part Number:	D2151
Inspection Dwg: D2151 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	0.099"	✓		✓	mm01
Ø0.171	+0.005/-0.000	0.172"	✓		✓	"
0.231	+/-0.010	0.232"	✓		✓	"
1.217	+/-0.010	1.219"	✓		✓	"
2.194	+/-0.010	2.193"	✓		✓	"
2.300	+/-0.010	2.302"	✓		✓	"
1.560	+/-0.010	1.563"	✓		✓	"
0.250	+/-0.010	0.249"	✓		✓	"
1.328	+/-0.010	1.327"	✓		✓	"
0.342	+/-0.010	0.344"	✓		✓	"
0.740	+/-0.010	0.738"	✓		✓	"
2.050	+/-0.010	2.054"	✓		✓	"
0.040	+/-0.010	0.040"	✓		✓	"

Measured by: JM	Audited by: SMB DAS	Prototype Approval:	N/A
Date: 12-7-23	Date: 12-7-24 15:00	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	BE

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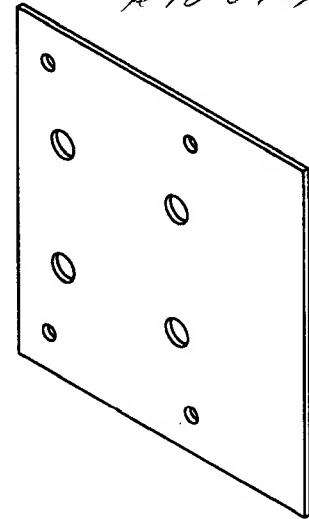
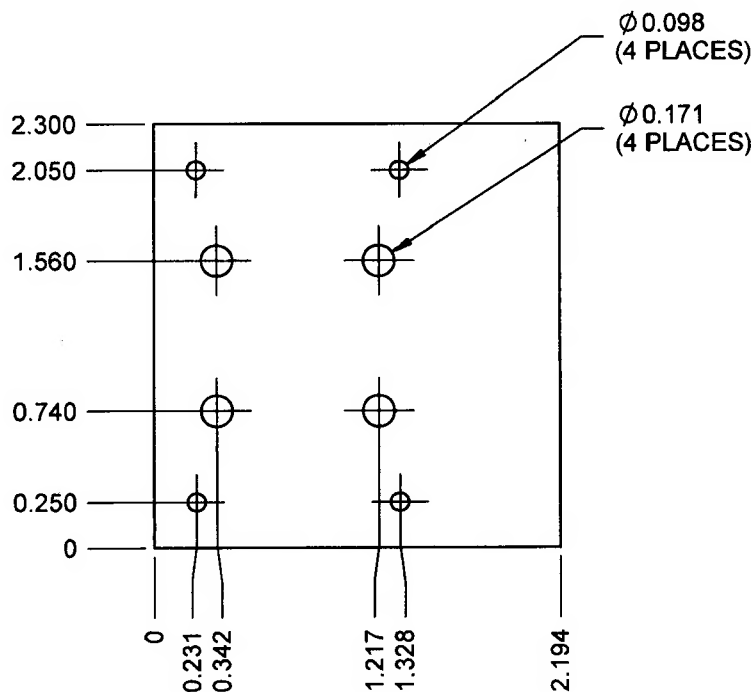
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2151	REV. B SHEET 1 OF 1
DATE 06.10.13		TITLE PACKER	SCALE 1:1
REV	DATE	DESCRIPTION	
A	95.05.01	NEW ISSUE	
B	06.10.13	UPDATE DRAWING	

RELEASED

06.11.20 [Signature]

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86831

21207-9



D2151 PACKER

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D2151" USING FINE POINT PERMANENT INK MARKER

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Dart Aerospace Ltd

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